

capilla[®] 317 - 17

Standards:

EN ISO 3581-A:	EZ 18 16 5 LR 32
EN 1600::	EZ 18 16 5 LR 32
AWS A 5.4:	E 317 L-17
Mat.-No.:	1.4440

Product description:

Rutile coated stick electrode for welding of austenitic stainless Cr-Ni-Mo steels with extra low carbon content;

Service temperatures up to 400°C;

The weld metal has a good resistance to IC- and pitting corrosion especially if exposed to chloridic media and is non-magnetic.

Applications:

Cladding and fusion welding of similar alloyed steel grades e.g.

1.4439, 1.4438, 1.4429.

Furthermore suitable for fusion welding of these steels with corrosion resistant Cr-steels and non-alloyed steels;
Buffer layers

Typical weld metal composition:

[wt. - %]

	C	Cr	Ni	Mo	N	Fe
Min.		18	16	4,0		
Max.	0,03	19	17	5,0	0,1	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	600	[MPa]
Yield strength $R_{p0,2}$:	440	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	70	[J]

Positions: all except PG

Redrying: 300°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,5	300	40 – 60	=(+)-
	2,5	300	50 – 90	
	3,25	350	80 – 110	
	4,0	350/450	100 – 150	
	5,0	450	150 – 200	

also available:
find in table of content

Capilla 317 MAG
Capilla 317 WIG